



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2963-125
Job Sheet 205210



5260731

Part No: D2963-125

Job Qty: 161 pcs

Part Name: 105 I-Beam Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/20

Job Tracking No:

Due Date: 3/13/20

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	161 pcs		3/13/20	0.00	0.00	Purchasing - 1		82 9-89 MAR 04 2020
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	161 pcs		3/13/20	0.00	0.00	Packaging 2 - 1 - B4B		82 9-89 MAR 4 2020
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

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				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
120 QC 6	161 pcs	3/13/20	0.00 0.00	QC 6 - 9	DAS 81 9-89
				QC 6 - 68	DAS 82 9-89
				QC 6 - 61	9-89
				QC 6 - 40	MAR 06 2020
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	161 pcs	3/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

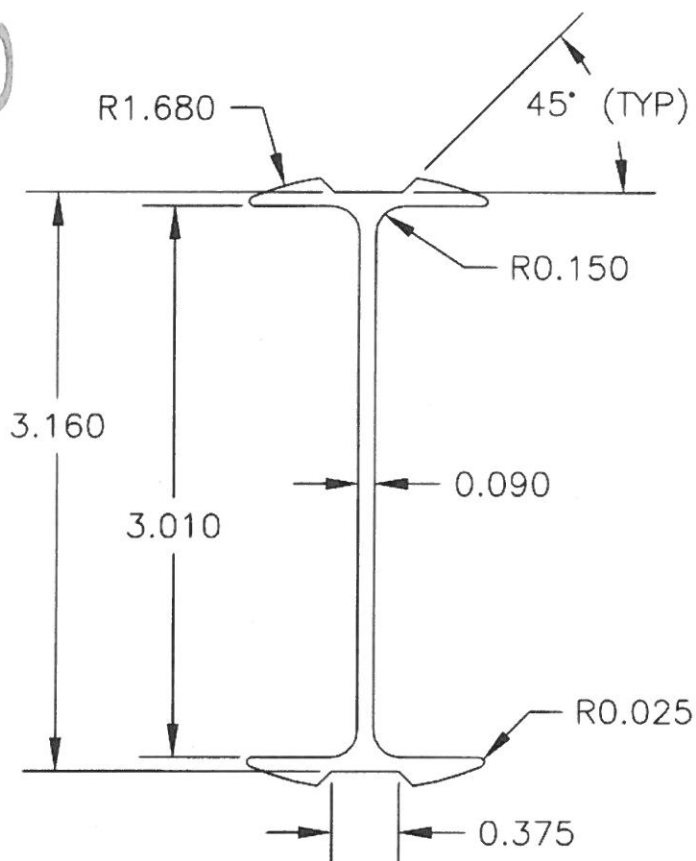
				Packaging 3 - 37 - B4B	TW 2020/03/10 MAR 10 2020
140 QC 21 - SA	161 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Purchasing) Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) 120 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
PO Details					
Signature Aluminum Canada Inc. (sig001-vc)  PO No: POHB045676 Line No: 1					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2963-125P	105 I Beam Extrusion	161 pcs (1 ea)	100-Purchasing	S259062	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing	D2963-125P	161	0	0	
Part Specifications					
Specifications could not be found.					

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DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2963	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE EXTRUSION	SCALE 1:1
A	00.03.10	NEW ISSUE	

RELEASED
00.05.11



GENERAL NOTES

1. MANUFACTURED USING BON L CANADA DIE # ~~TBD~~ DAA-848294
2. ORDER AS D2963-XXX WHERE XXX = LENGTH IN INCHES
EG. 84 LONG: D2963-084
3. MATERIAL: 6061-T6 (QQ-A-200/8)
MINIMUM YIELD TENSILE STRENGTH = 35 ksi ✓
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi ✓
MINIMUM ELONGATION = 8 % ✓

#00.06.08
CP 00.06.08

DAS
82
9-89

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

4. BREAK ALL UNMARKED SHARP CORNERS 0.016-0.025
5. NO TOOLING MARKS.
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
7. ALL DIMENSIONS ARE IN INCHES.

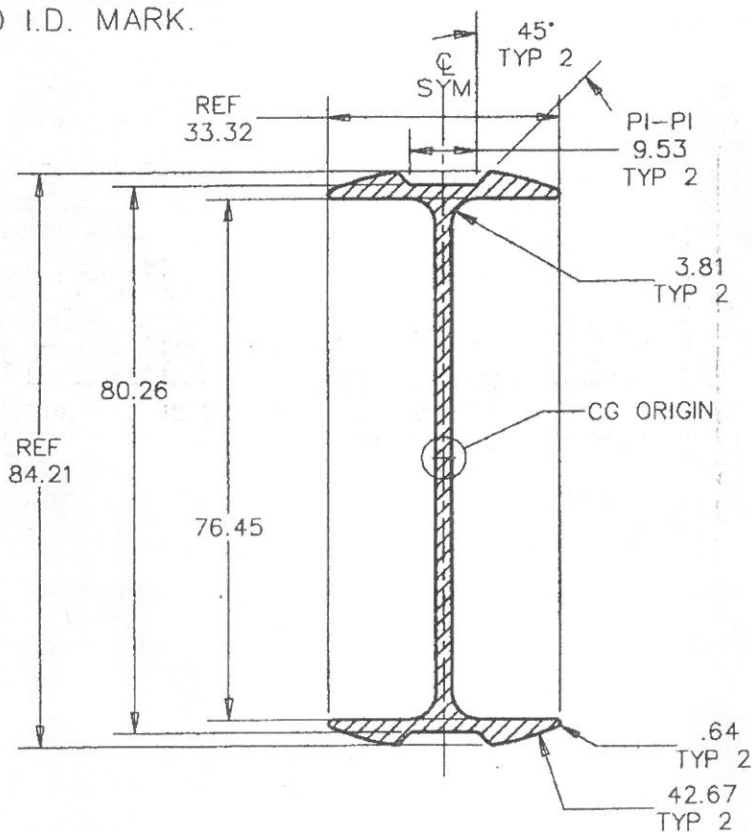
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Standard Aluminum Association tolerances apply unless otherwise noted.			DIE NUMBER	REV
CUST PART #: S-3982	PLANT	EUC	DAA-2	
CUST PART NAME:	AUR	204		
PROPOSAL:	REL. DATE	ALLOY 6061-T6	FINISH AE	

DART AEROSPACE LTD.
ASSUMES BURDEN OF
PROOF OF BONNELL
METAL IDENTIFICATION
WITH NO I.D. MARK.

ORIGINAL



LOCATION	12.04
COPY NO.	2
PRIMARY PRESS	6
ALT PRESS	--
ALT PRESS	--
CAVITIES	2
STACK SIZE	244 x 127
DIE TYPE	FEEDER
HOLDER	2167
BOLSTER NO.	SIZE
7-262	203
BO. LOC.	P-163
SUB BO. NO.	SIZE
SHIM	SIZE
DIE	SIZE
DAA-2	25
FEEDER	SIZE
DAA-2	51
BACKER	SIZE
DAA-2	51
BA. LOC.	12.04
ROMI-SHAPE	YES
CAV. DEPTH	51
CAV. CCD	
DIE MAKER	ETS

DATE REQUESTED

ORDER CODE

- ☐ NEW
- ☐ REPLACE
- ☐ BACKUP
- ☐ REINSTATE
- ☐ REVISE
- ☐ REPAIR
- ☐ UNIT
- ☐ DIE AND FEEDER
- ☐ DIE ONLY
- ☐ BACKER ONLY
- ☐ FEEDER ONLY
- ☐ MANDREL ONLY
- ☐ BOLSTER TO SUIT

REV	DESCRIPTION OF REVISION	5/31/0	BMR
	REVISIED DIE NUMBER FROM DAA-2 TO DAA-848294	DATE	BY
Structural values estimated for reference only.			
Ix:	.3630 x 10 ⁶ mm ⁴	.872 in ⁴	Iy: .0146 x 10 ⁶ mm ⁴
Sx:	8.619 x 10 ³ mm ³	.526 in ³	Sy: .874 x 10 ³ mm ³
CGx:	42.11 mm	1.658 in	CGy: 16.66 mm
			.656 in

CUSTOMER: 46024
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7



THE WILLIAM L BONNELL CO
CAPITOL PRODUCTS CORPORATION
BON•L•CAMPO, LP BON•L•CANADA, INC
SUBSIDIARIES OF TREDEGAR INDUSTRIES, INC

UNSPECIFIED WALLS:	2.27 mm	MASS:	.977 kg/m	.656 lb/m
	.090 in	EST PER:	282.65 mm	11.128 in
UNSPECIFIED RADII:	0.41R mm	OUT PER:	mm	in
	.016R in	EXP PER:	mm	in
DATE:	5/17/0	BUFF PER:	mm	in
DRAWN:	MLJ	BUFF TURNS:	CLASS:	Solid
SCALE:	FULL	FACTOR:	289 metric	17 imperial
THM BAR:	NO	C.C.D.:	86.59 mm	3.409 in
P&D CODE:	NO	P&D AREA:	mm ²	in ²

DAA-2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045676**



REVISED

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB045676

PO Date: 1/24/20

Due Date: 2/21/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205210	D2963-125P	D2963-125 Rev A		105 I Beam Extrusion as per Dwg D2963 Rev A Die # DAA-848294 Length 125"	Firmed	-	2/21/20	180 pcs	0 pcs	180 pcs	\$16.5813/pcs	\$2,984.63
										180 PLS 603		FEB 27 2020 DAS 82 9-59	
Grand Total:													\$2,984.63

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 2/25/20 2:37 PM Dart.Guerin.Kimberley



Tel (613) 632-5200

PURCHASE ORDER
POHB045676



Special Comments:

E-MAILED
2020-01-24

Items

Grand Total: \$2,669.59

Order Notes

A049 SUPPLIER AWARENESS

Plex 1/24/20 9:24 AM Dart.Guerin.Kimberley



1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.com

PACKING LIST

PACKING LIST DATE / DATE DU BORDÉREAU

02-25-20

PACKING LIST NUMBER / N° DE BORDÉREAU

046848

SALES ORDER NUMBER / N° DE COM

139068

INVOICING AND COMPANY LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.

1270 ABERDEEN ST.

HAWKESBURY, ON K6A 1K7

CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.

1270 ABERDEEN ST.

HAWKESBURY, ON K6A 1K7

CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO THESE NUMBERS ON ALL CORRESPONDANCE
REFEREZ-VOUS À CES NUMÉRIQUES POUR TOUTE CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT

46024

ORDER DATE / DE LA COM

01/29/20

CUSTOMER PO NUMBER / CLIENT PO Number

POHB045676

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

046848

LOCATION TRAILER NUMBER / REMORQUE Numéro

PIC

F1336

SALESMAN / VENDEUR

042

CREDIT REP / REP DU CRÉDIT

SALES REP / REP DES VENTES

GATTENBOROU

JOB / FICHIER

CARRIER / TRANSPORTEUR

CANUS/KANINE

FIELD SALES REP / REP REGIONAL DES VENTES

CUST SERVICE REP / SERVICE CLIENTÈLE

GATTENBOROU

D1K

ITEM NO. / QUANTITÉ D'ORDRE ORIGINAL UNIT / SHIPPED QUANTITY / PREVIOUS PRECEDENT QUANTITY LIVRÉE

001 1,105 LB 501 KG 163 PC DAA-2-3 D2963125 6061 T6 125.0000 IN Cut (+): 0.1180 Cut (-): 0.0000

Y 1,105 LB 501 KG 163 PC DAA-2-3 D2963125 6061 T6 125.0000 IN Cut (+): 0.1180 Cut (-): 0.0000

932697 / 537692 1 604 578 90 PC 932697 / 537693 1 604 578 90 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping/packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTOMER

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
02/19/2020	5568268	139058	1
Cust PO	B/L No	Lot	Date
POHB045676	046848	932697	02/25/20

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-2-3	125" MILL 6061 T6	D2963125
Gross Weight	1,208 LBS		
Net Qty	1,155 LBS	180 PCS	2 PKGS
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE	DAS
MPA / KSI	MPA / KSI				
315.9 / 45.8 ✓	286.2 / 41.5 ✓	8.2 ✓	N/A	91	82 9-85

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.65	0.25	0.22	0.06	0.91	0.07	0.13	0.02	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

LINE 1

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2963-125P

PO / BATCH NO.: POH13045676

DATE: MAR 04 2020

5259062

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: Ø

QUANTITY RECEIVED: 180 PLS

THICKNESS RECEIVED: Ø

QUANTITY INSPECTED: 180 PLS

SHEET SIZE ORDERED: 125" LONG

QUANTITY REJECTED: Ø

SHEET SIZE RECEIVED: 125" LONG

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	AMS - QQ-A-20018
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	HIT 932697
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 82</u> DATE: <u>MAR 04 2020</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in